

The embodiments of the invention in which an exclusive property or privilege is claimed are defined as follows:

1. A method for forming an Arundo donax pulp, comprising:
  - (a) subjecting a furnish comprising Arundo donax particles to a pulping process to provide Arundo donax pulp; and
  - (b) bleaching the Arundo donax pulp by a total chlorine free process.
2. The method of Claim 1, wherein bleaching comprises the sequence: O(Q)-Eop-P-P-P.
3. The method of Claim 1, wherein bleaching comprises the sequence: O(Q)-Eop-P-Pp-P.
4. The method of Claim 1, wherein bleaching comprises the sequence: O-A-P-P-P.
5. The method of Claim 1, wherein bleaching comprises the sequence: O-Eop-P-Q-P-P.
6. The method of Claim 1, wherein bleaching comprises the sequence: O-Eop-Q-P-P-P.
7. The method of Claim 1, wherein bleaching comprises the sequence: O-Q-Eop-P-P-P.
8. The method of Claim 1, wherein bleaching comprises the sequence: O(Q)-Eop-P-P-P.
9. Total chlorine free bleached Arundo donax pulp.